Work Order ID 117855

May-05-14 11:46:08 AM

117855

Item ID: D2037-101 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Arm

Start Date: 5/05/14 **Start Qty:** 4.00 *4*
Required Date: 5/05/14 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ML5 **Date:** 14-05-06 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2037 / D ✓									
100		0.00							
100	NC BRAKE				DAS 30 9-89	4			
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1								
110		0.00							
110	Small Fab				DAS 28 9-89	4X		NOV 12 2014	
Small Fab	**Memo**	0.00							
Small Fab	1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 ends of D2037-101 tube as required using DT8545 3-Deburr as required		2-Flatten						
120	QC5- Inspect part completeness to step on W/O	0.00							
120					DAS 38 9-89	(4)			
QC	**Memo**	0.00							
Quality Control									

NOV 14 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location WA001	0.00				4			DAS 86 NOV 15 2014
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							14/11/14
140									
QC	**Memo**	0.00							
Quality Control									

MF
14-11-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

NCR No. _____

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Large Fab ☐ Composite ☐ Supplier ☐ ☐

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Doc/Data	☐									
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Operator	☐									
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Training	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

May-05-14 11:46:08 AM

Work Order ID: 117855 **117855**

Parent Item: D2037-101 **D2037-101**

Parent Item Name: Arm

Start Date: 5/05/14 **Required Date:** 5/05/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 05-11-01 JLM
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			110	f	123.7261	4.916	17			

M304TR0.750W.049

304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code
MAT017	123.7261	
122312	4.04	
124768	49.27	
M126183	25.4399	
M128084	44.9762	

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Part No. _____

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description: Arm Work Order: 117855

Inspection Drawing: D2037 Rev: 1 Part Number: D2037-101

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.30	+/-.030	46.30	✓		T	SS-5
45.50	+/-.030	45.50	✓		T	SS-5
Ø.327	+/.005					

DAS

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*
DAS 30 9-89	36 9-89		
Date 14/06/10	Date 14/06/10	Date	Date